

Work Order ID 80752***80752***

Page 1

February-28-12 1:16:58 PM

Item ID: D4281-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 28/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *MLJ*Date: *12/02/28* Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4281	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <i>B</i> Prog Rev: <i>B</i> 2-Deburr if necessary								
	3-OPEN HOLES ON DRILL PRESS AS PER DWG								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

*B12-3-3**(6)**B12-3-3*

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Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Manufacture as per dwg

0.00

130

Mill Conv

Memo

0.00

Conventional Milling Machine

1- Face to size as per dwg
2- deburr

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

12-3-5

5/2/13/15

(46)

6X Ø M-L 12/03/05

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Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

0.00

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

180

Identify as per dwg & Stock Location: 139A

0.00

180

Packaging

Packaging

Memo

0.00

bxd m/ 12/03/07

bx d m 12/03/08

12/3/8 sd 16

m 120222

*3:45
3200 F
4:15*

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/03/08

MLJ 12/03/08



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Picklist Print

February-28-12 1:17:03 PM

Page 1

Work Order ID: 80752

80752

Parent Item: D4281-3

D4281-3

Parent Item Name: Spacer

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X02.00 0		Purchased	No				f	15.6990		0.698947			

M6061T6B0 750X02 000

6061-T6 Bar .750 x 2.00

**

18123-3

Location

Loc Qty

Loc Code

MAT002

15.699

100742

3.271

111448

6.219

119653

6.209

100742

6

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DART AEROSPACE LTD		Work Order:	80752
Description: Spacer		Part Number:	D4281-3
Inspection Dwg: D4281	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.134	x		✓ IBGZ	
Ø0.250	+0.005/-0.001	.258	2		✓	
0.88	+/-0.030	.877	2		✓	
0.063	+/-0.010	.066	2		✓	
0.440	+/-0.010	.433	2		✓	
0.760	+/-0.010	.755	2		✓	
0.500	+/-0.010	.499	2		✓	
0.900	+/-0.010	.900	2		✓	
0.88	+/-0.030	.88	2		✓	
1.13	+/-0.030	1.13	2		✓	
1.65	+/-0.030	1.645	2		✓	
0.125	+/-0.010	.123	2		✓	
0.89	+/-0.030	.881	2		✓	
2.00	+/-0.030	2.002	2		✓	
0.735	+/-0.010	.739	—		RA26	✓

Measured by: RB <i>JD</i>	Audited by: J	Preliminary Approval:
Date: 12-3-3 12-8-5	Date: 12/13/15	Date:

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	<i>JD</i>

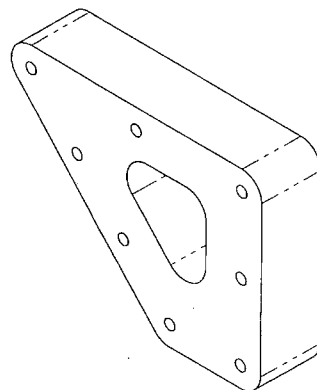
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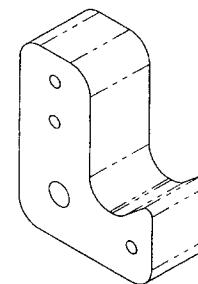
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D4281-1 SPACER



D4281-3 SPACER

80752 MLJ
12/02/28

RELEASED
2011-07-28
ANT

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.34 lbs
-3: 0.15 lbs

B	ADDED SHT 2, ADDED -3	AJS	11.07.04
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG: APPR.		D4281	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
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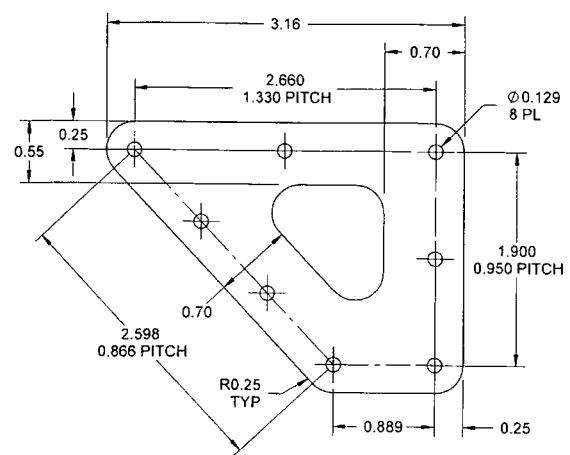
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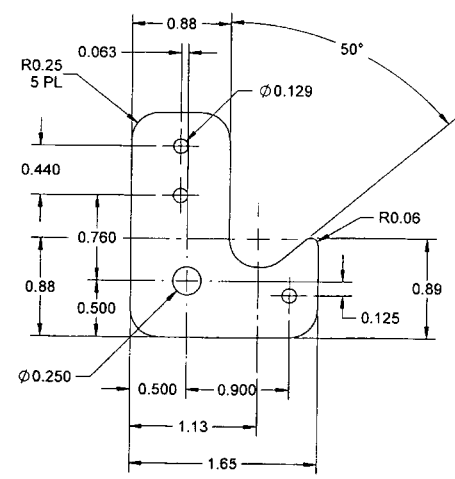
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D4281-1 SPACER



D4281-3 SPACER

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
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